

Date: Wednesday, 29/04/2009 10:28:02 AM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | PANEL |
| Job Number : | 47591 | | |
| Estimate Number : | 10873 | | |
| P.O. Number : | | Part Number : | D32455 |
| This Issue : | 29/04/2009 | Drawing Number : | D3245 REV B |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | 29/04/2009 | Drawing Revision : | B |
| Previous Run : | 46174 | Material : | |
| Written By : | | Due Date : | 06/05/2009 |
| Checked & Approved By : | Qty: 10 Um: Each | | |
| Comment : | Est. A 04.07.07 New issue KJ/JLM | | |
| | Est Rev:b ECN 1052 07-10-31 DD verified by: | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S22GA | 304/316 .032 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0735 sf(s)/Unit Total: 0.7350 sf(s)
 304/316 .032 Sheet
 Batch: 109057 RB 9-4-30

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3245
 Dwg Rev: B
 Prog Rev: B RB 9-4-30
 2-Deburr if necessary RB 9-4-30

(15)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RB 9-4-30

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

S 02/04/30 (415)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Deburr if necessary
 Form D3245-5 as per Dwg D3245 Identify as D3245-5

S 09/04/30 (15)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:28:03 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 47591

Part Number: D32455

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/30 (25)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 19

9/5/11

(50)

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/01 48

Job Completion



MF

09-09-01

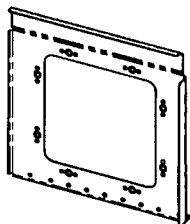
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

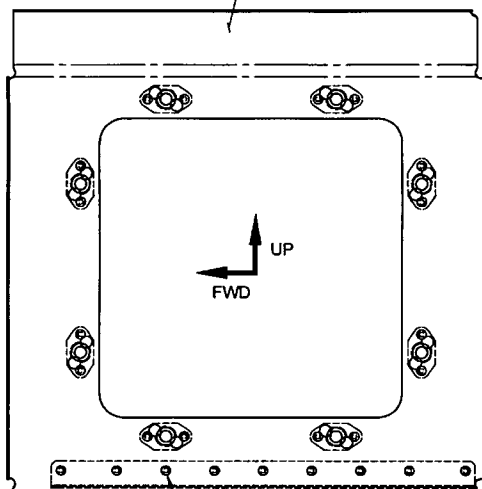
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



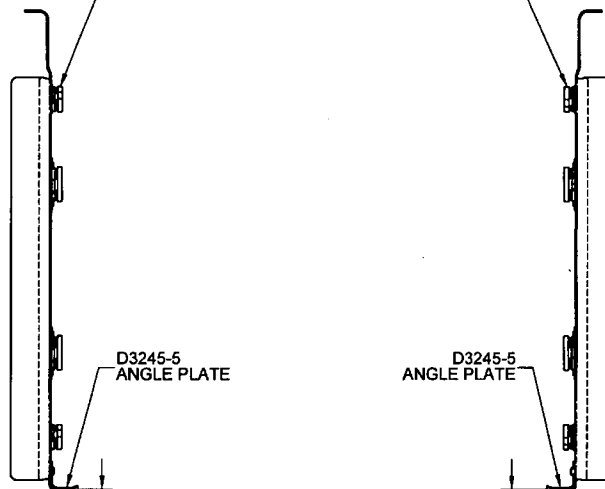
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

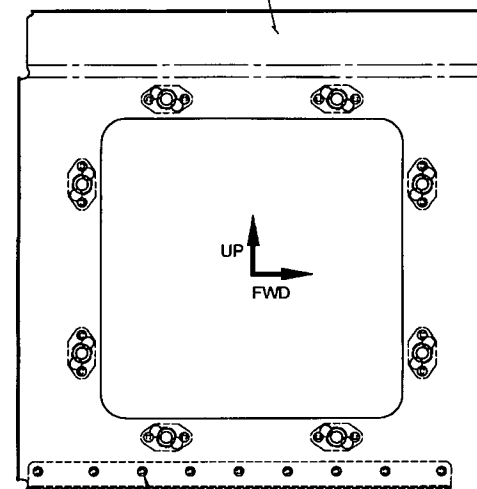
D3245-041 ACCESS PANEL ASSEMBLY



| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|-------------|-------------|-------------|---------------------------|
| X | | D3245-041 | ACCESS PANEL ASSEMBLY, LH |
| | X | D3245-042 | ACCESS PANEL ASSEMBLY, RH |
| 1 | | D3245-1 | PANEL |
| | 1 | D3245-2 | PANEL |
| 1 | 1 | D3245-5 | ANGLE PLATE |
| 8 | 8 | 2350-18-C3Y | DZUS RIGID RECEPTACLE |
| 16 | 16 | MS20427M3-3 | RIVET |
| 9 | 9 | MS20615M3-3 | RIVET |

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

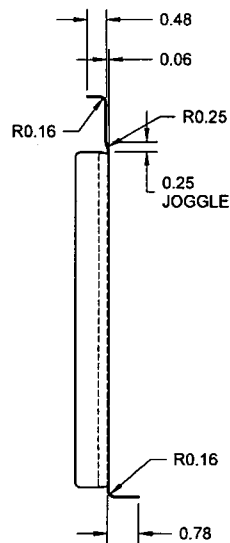
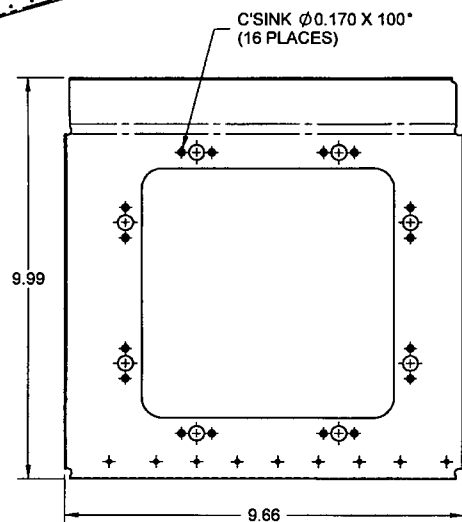
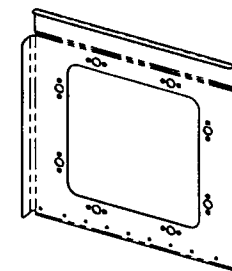
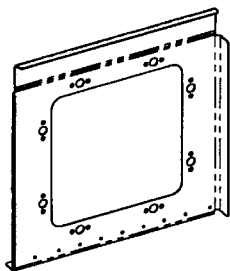
RELEASED
14 07-10-23

NOTES:

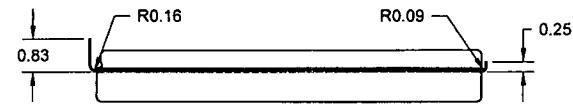
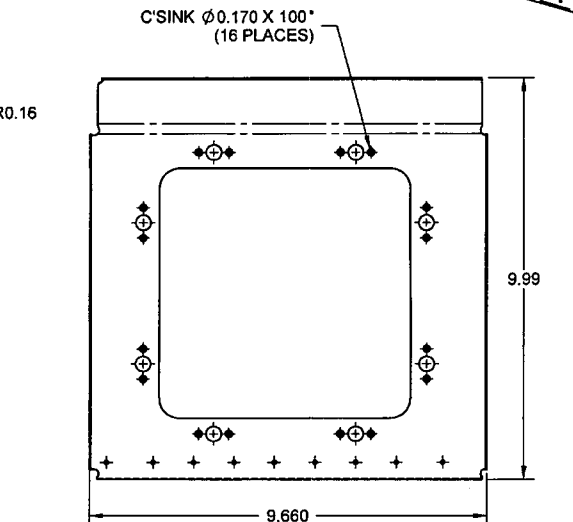
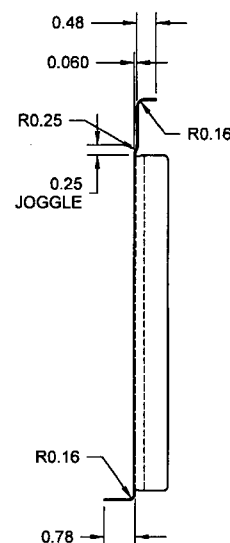
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

| | | | |
|--|--|--|----------|
| B | REMOVE Ø0.204 HOLES FROM D3245-1/-2. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING | MB | 07.10.02 |
| A | NEW ISSUE | RF | 04.01.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.10.02 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. B SHEET 1 OF 7 SCALE 1:2.5 | |
| DRAWING NO. D3245 | | | |
| TITLE ACCESS PANEL ASSEMBLY | | | |
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D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

RELEASED
10-23

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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SUBJECT TO AMENDMENT

WITH NOTICE

WORD ORDER

| | | | |
|------------|----------|--|--------------|
| DESIGN | 7F | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | DRAWING NO. | REV. B |
| CHECKED | PH | D3245 | SHEET 2 OF 7 |
| MFG. APPR. | DS | TITLE | SCALE |
| APPROVED | MP | ACCESS PANEL ASSEMBLY | 1:3 |
| DE APPR. | MP | COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 07.10.02 | | |

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

D3245-7 GASKET
(REF)

8.00
(TYP, REF)

D3245-043 DOOR ASSEMBLY

INSTALL D3245-7
GASKET ON THIS SIDE

| QTY -043 | P/N | DESCRIPTION |
|-------------|-----------------|-----------------------|
| X | D3245-043 | ACCESS PANEL ASSEMBLY |
| 1 | D3245-3 | DOOR |
| 1 | D3245-7 | GASKET |
| 8 | 2351-20-009-C3Y | STUD |
| 8 | 127H-35 | GROMMET |

NOTES:

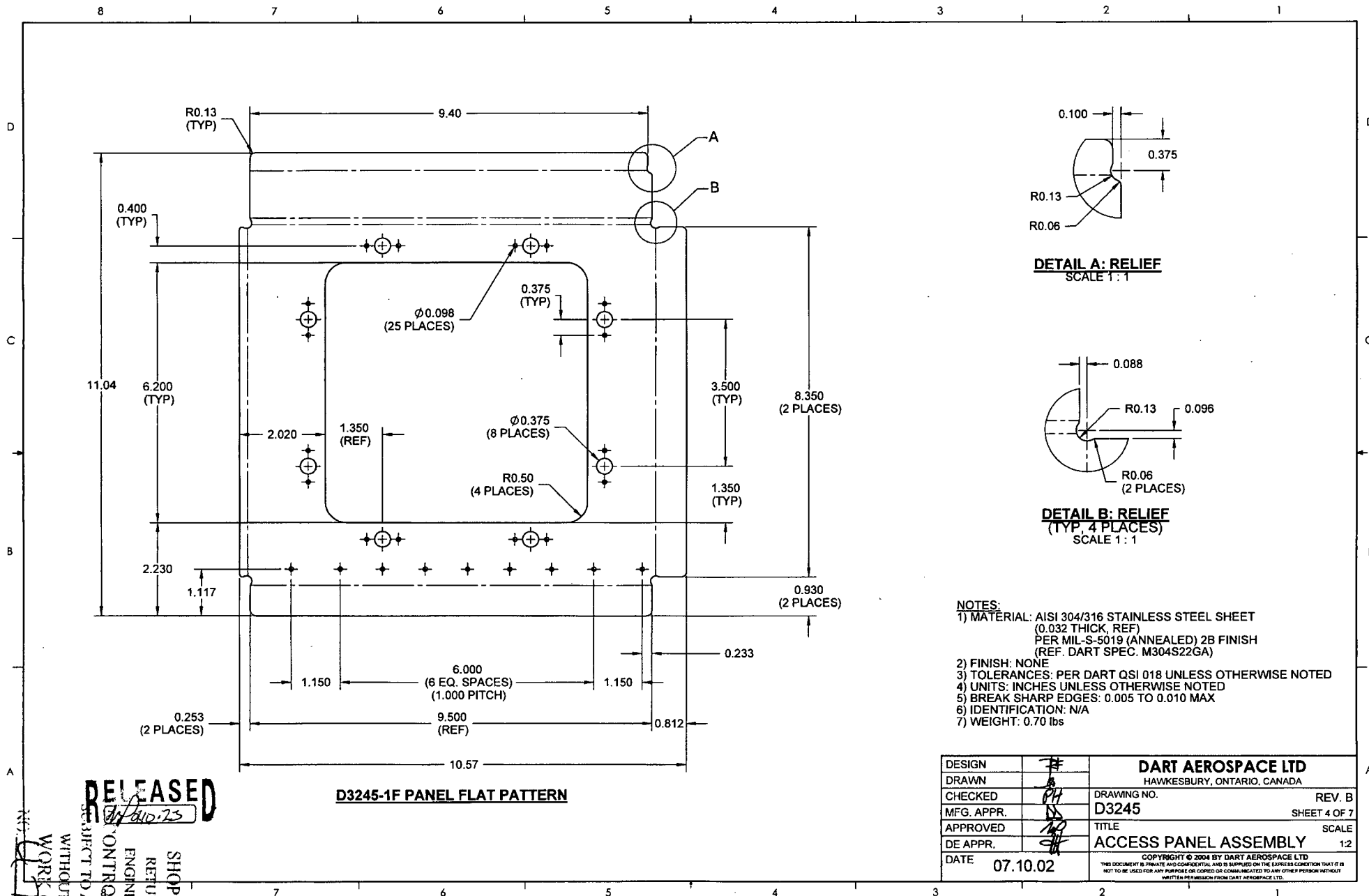
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

| | | |
|------------|--------------------|--|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. REV. B |
| MFG. APPR. | <i>[Signature]</i> | D3245 SHEET 3 OF 7 |
| APPROVED | <i>[Signature]</i> | TITLE SCALE |
| DE APPR. | <i>[Signature]</i> | ACCESS PANEL ASSEMBLY 1:2 |
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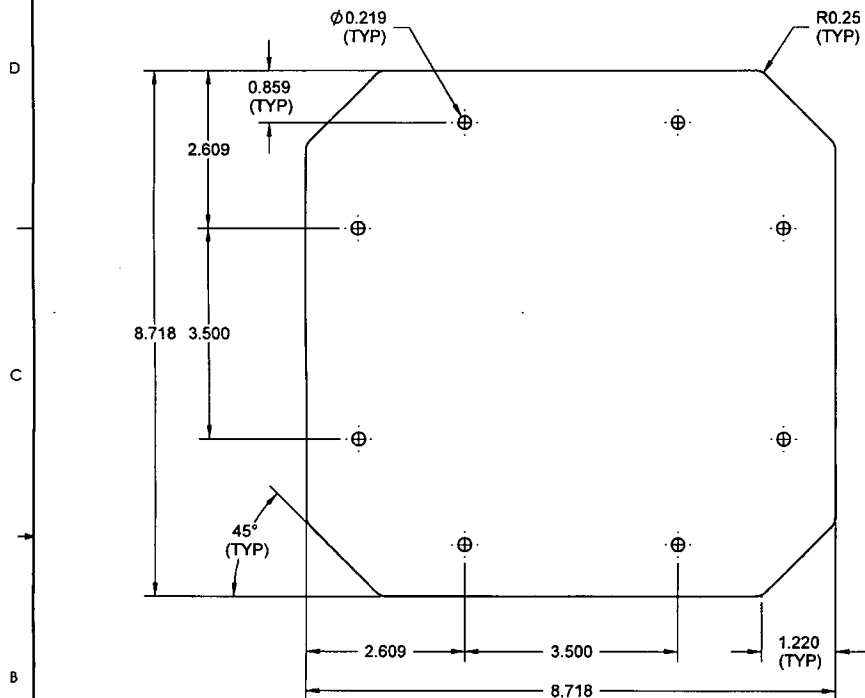
7 6 5 4 3 2 1



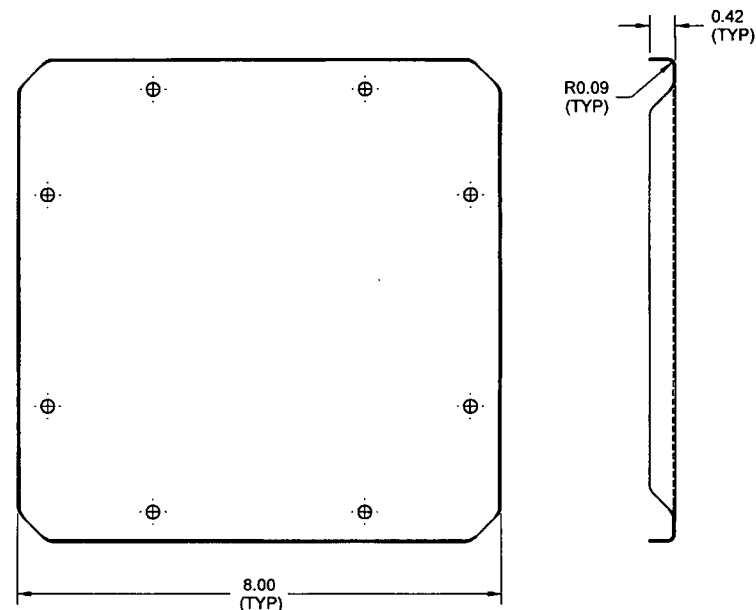
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07-10-23

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8 7 6 5 4 3 2 1



D3245-3F DOOR FLAT PATTERN

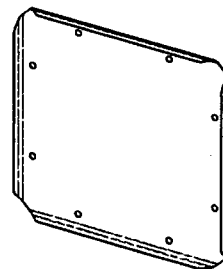


D3245-3 DOOR BENDING DETAIL

RELEASED
07-10-02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

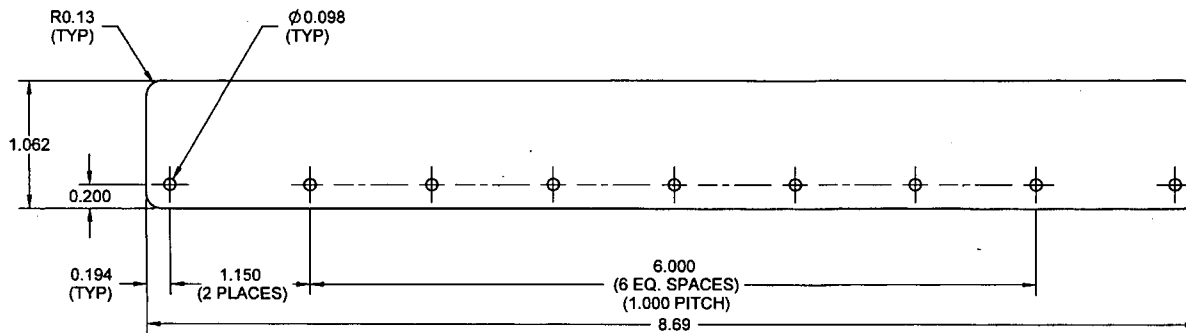
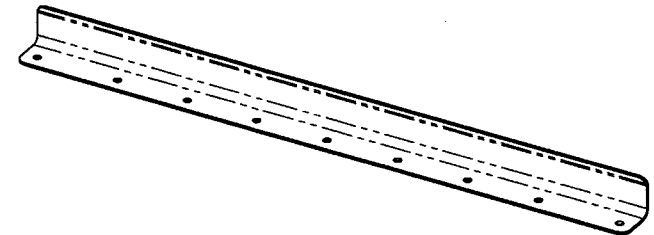


| | | | |
|------------|----------|--|--------------|
| DESIGN | DF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | DRAWING NO. | REV. B |
| CHECKED | PH | D3245 | SHEET 5 OF 7 |
| MFG. APPR. | DS | TITLE | SCALE |
| APPROVED | PH | ACCESS PANEL ASSEMBLY | 1:2 |
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| DATE | 07.10.02 | | |

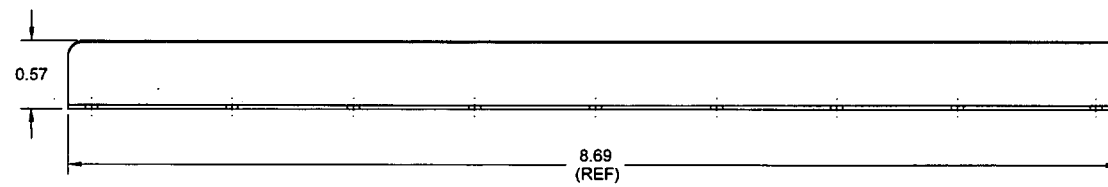
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WORK ORDER
NO 47581
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7 6 5 4 3 2 1

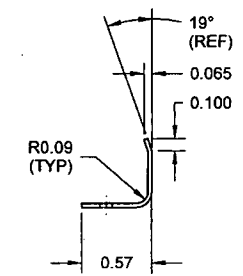
8 7 6 5 4 3 2 1



D3245-5F FLAT PATTERN



**D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)**

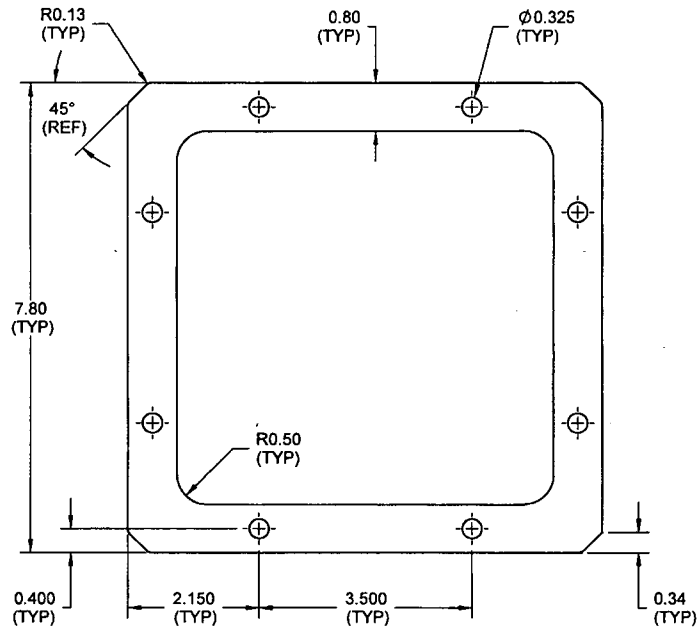


RELEASED
07.10.23

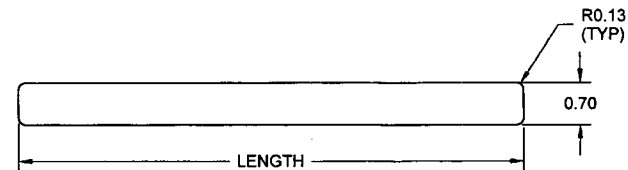
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

| | | | |
|--|---------------|--|--------------|
| DESIGN | TH | DART AEROSPACE LTD | |
| DRAWN | TH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | TH | DRAWING NO. | REV. B |
| MFG. APPR. | TH | D3245 | SHEET 6 OF 7 |
| APPROVED | TH | TITLE | SCALE |
| DE APPR. | TH | ACCESS PANEL ASSEMBLY | |
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D3245-7 GASKET



D3245-X GASKET

| P/N | LENGTH |
|----------|--------|
| D3245-9 | 8.35 |
| D3245-11 | 9.01 |
| D3245-13 | 9.50 |

RELEASED
07/10/02

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|------------|----------|--|--------------|
| DESIGN | 7F | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | DRAWING NO. | REV. B |
| CHECKED | PH | D3245 | SHEET 7 OF 7 |
| MFG. APPR. | DS | TITLE | SCALE |
| APPROVED | DS | ACCESS PANEL ASSEMBLY | 1:2 |
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